

Work Order ID 166501

Monday, September 25, 2017 11:03:57 AM

166501*Rush*
Ship Date 9/9/27 Page 1

Item ID: D3796-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Wearplate Weldment

Start Date: 9/25/2017 Start Qty: 3.00

3*1 cm*

Cust Item ID:

Required Date: 10/3/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: *um*Date: *7/9/25*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3796

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.51

FLOW CNC Waterjet

1-Cut as per Dwg D3796 Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

*①**α 17/09/25*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*①**α 17/09/25*

Work Order ID 166501

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166501

Page 2

Item ID: D3796-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Wearplate Weldment
Start Date: 9/25/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 10/3/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
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120

QC

Memo

Quality Control

① 17-09-25 PD.

130	Weld per dwg A/R S.S. rod Batch: _____	0.00							
-----	--	------	--	--	--	--	--	--	--

130

Large Fab

Large Fab

Memo

Large Fab

Weld hardcoat (template DT9877) and cups as per dwg D3796 using DT9040 jig

2059 hardcoat batch: 13239304/316 S.S. ROD batch: 134992

1 17-09-26

JBK / Q.L.

140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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140

QC

Memo

Quality Control

1 SEP 25 2017 DAS 24 9-89

Work Order ID 166501

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Page 3

Item ID: D3796-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Wearplate Weldment
 Start Date: 9/25/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 10/3/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1	SEP 25	2017	DAS 24 9-89
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>Sold</u>	0.00				1	SEP 25	2017	DAS 24 9-89
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

WY 17/9/26

Picklist Print

Monday, September 25, 2017 11:03:56 AM

Page 1

Work Order ID: 166501

166501

Parent Item: D3796-043

D3796-043

Parent Item Name: Aft Wearplate Weldment

Start Date: 9/25/2017

Required Date: 10/3/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-08-05 new issue DD verified by:ec
IPP Rev:B 08-09-10 revA as per dwg (ecn 08-513) DD VERF:EC IPP REV:C
AS PER PB1 12-07-04 JLM VERIOFIED BY:DD IPP REV:D
12.09.06 PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4379-3

Manufactured

No

130

Each

30,0000

12

36

D4379-3

Wearplate Cup

**

17-09-26
JBC

Location

Loc Qty

Loc Code

WA002

30

157308

30

12

M304S16GA

Purchased

No

100

sf

163.4500

1.912

6.037895

M304S16GA

304/316 Sheet .063

**

217/09/25

Location

Loc Qty

Loc Code

MAT010

163.45

m138175

16.4

m138346

29.9

m138588

117.15

1.9

8 7 6 5 4 3 2 1

D

D

C

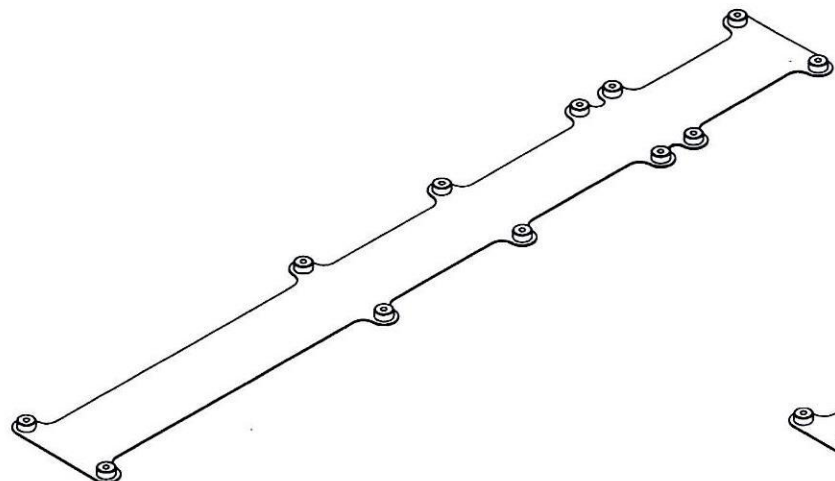
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B

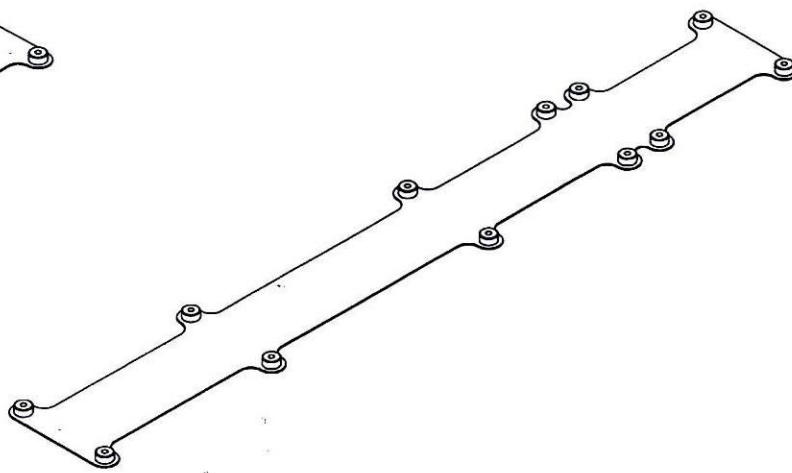
B

A

A



D3796-041 FWD WEARPLATE WELDMENT



D3796-043 AFT WEARPLATE WELDMENT

SHOP COPY

(Drawing)

COMPILING

RECEIVED COPY

WELDMENT

NOTICE

ORDER

166501

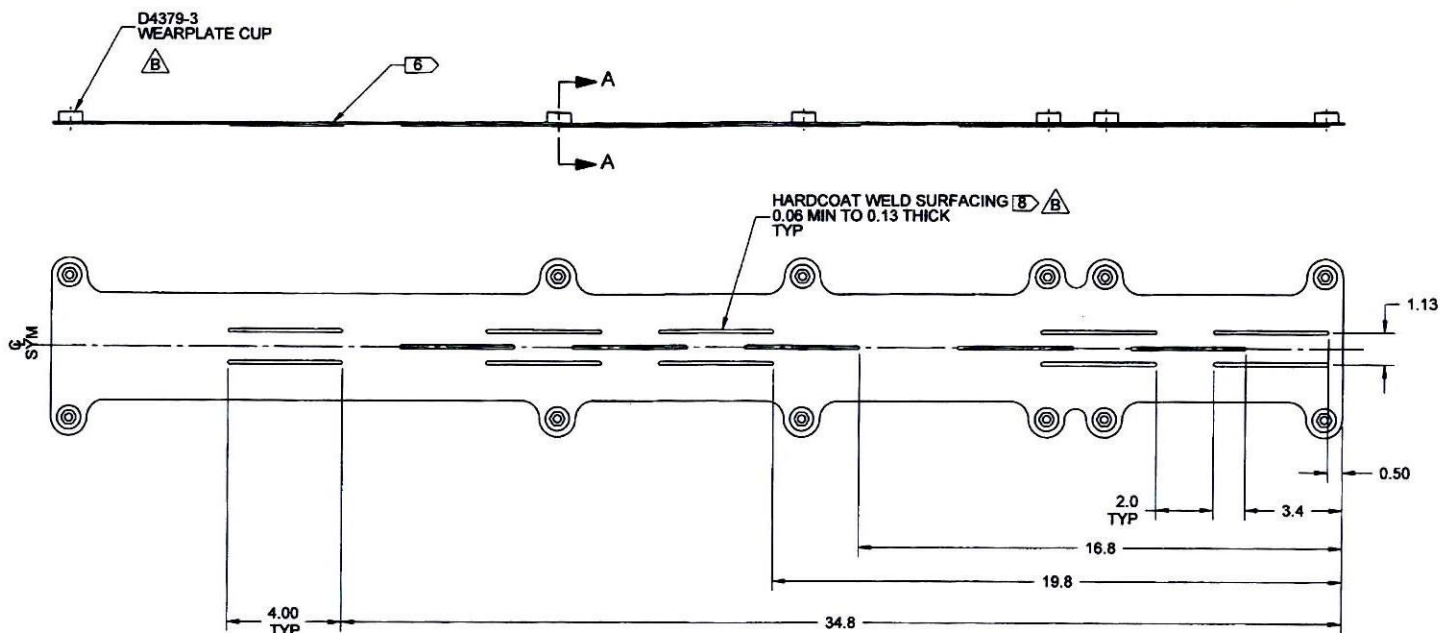
CU 17/19/25

RELEASED
2012-08-10

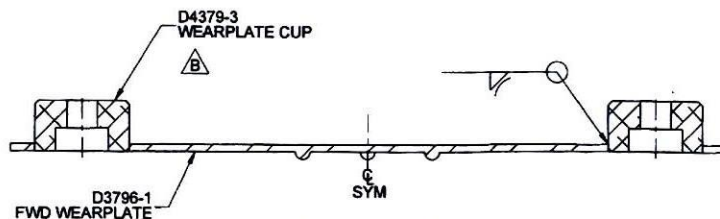
B	REPLACED D3009-3 CUP WITH D4379-3 WEARPLATE CUP; REMOVE REFERENCE TO 2059 HARDCOAT WELD SURFACING TO ALLOW ALTERNATIVE HARDCOAT MATERIALS PER QSI 004 (C4-2 & C5-3); REMOVE POWDER COAT FINISH NOTE 2 (SHEETS 2 & 3)		AP	12.07.04
A	NEW ISSUE		MB	08.08.01
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	AP	DRAWING NO.	REV. B	
MFG. APPR.	AP	D3796	SHEET 1 OF 4	
APPROVED	AP	TITLE	SCALE	
DE APPR.	AP	412 SKI WEARPLATE	NTS	
DATE	12.07.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
041		
X	D3796-041	FWD WEARPLATE WELDMENT
1	D3796-1	FWD WEARPLATE
12	D4379-3	WEARPLATE CUP



D3796-041 FWD WEARPLATE WELDMENT



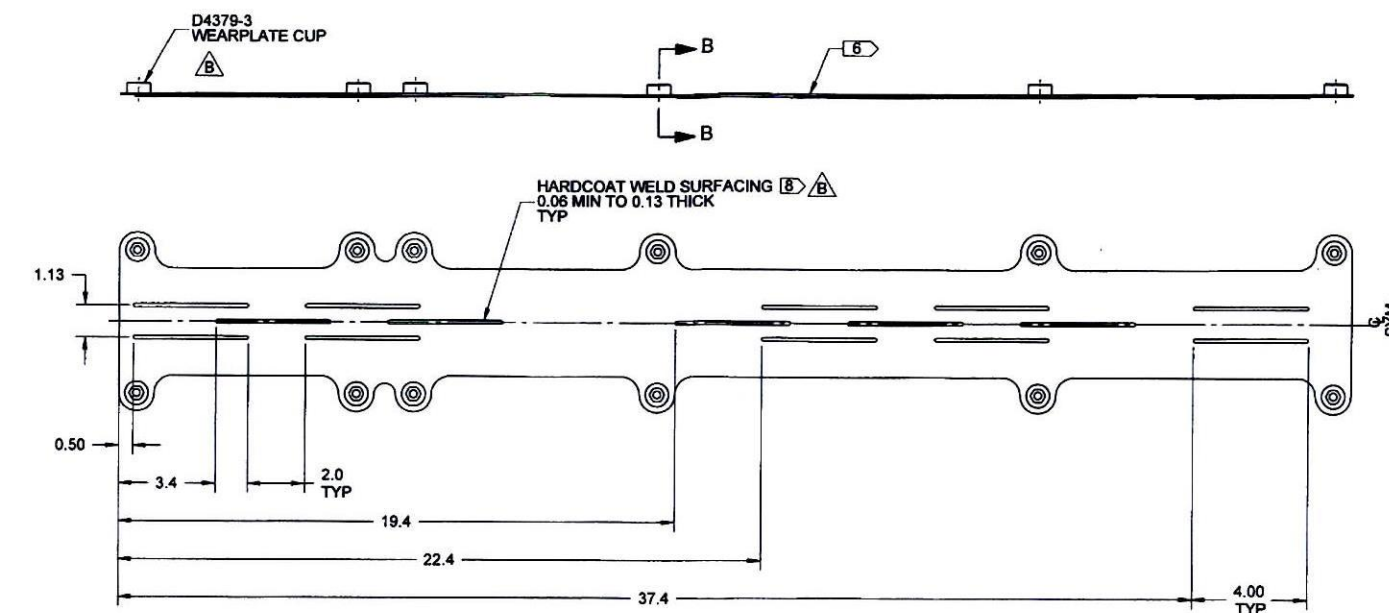
SECTION A-A
SCALE 4X, TYP

RELEASED
2012-08-10

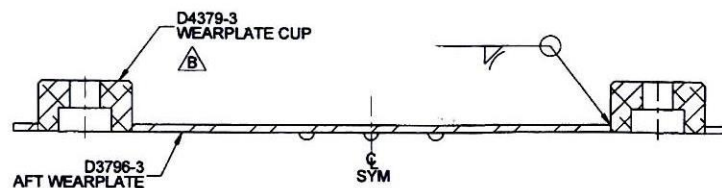
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 044
 - 7) WEIGHT: 4.00 lbs
 - 8) WELD PER DART QSI 004

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
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APPROVED	MS	TITLE	SCALE
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QTY -043	P/N	DESCRIPTION
X	D3796-043	AFT WEARPLATE WELDMENT
1	D3796-3	AFT WEARPLATE
12	D4379-3	WEARPLATE CUP



D3796-043 AFT WEARPLATE WELDMENT



**SECTION B-B D5-3
SCALE 4X, TYP**

RELEASED
2012-08-10
JW

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 004
 - 7) WEIGHT: 3.86 lbs
 - 8) WELD PER DART QSI 004

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 SKI WEARPLATE	NTS
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